

Work Order ID 130997

130997

March-26-15 1:34:57 PM

Page 1

Item ID: D2360

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Litter Tie Down Bracket

Stop ***NS2***

Start Date: 3/26/15

Start Qty: 500

5

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 500

5

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 15-03-30 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2341	Rev F								
D2360	Rev D								

100

0.00

100

Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.65" Long

3 0 15/04/10

110

0.00

110

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2341 and Dwg D2341
2-Deburr

3 0 15/04/10

DAS
08
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130997

130997

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Item ID: D2360 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Litter Tie Down Bracket
 Start Date: 3/26/15 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M131545.</i> Memo START TIME: <i>11:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:30</i>	0.00 0.00				<i>3</i>	<i>15-4-15.</i>		<i>DAS 34 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(3)</i>			<i>DAS 38 9-89</i> <i>APR 15 2015</i>
170 *170* Small Fab Small Fab	Small Fab Memo Assemble as per dwg D2360 <i>open holes #D .246</i>	0.00 0.00				<i>3X</i>		<i>15/04/15</i>	<i>DAS 36 9-89</i> <i>15-04-15</i>

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Process									
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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130997

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Item ID: D2360 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Tie Down Bracket
 Start Date: 3/26/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00				(3)			DAS 38 9-89
180									
QC	Memo	0.00							
Quality Control									APR 16 2015
190	Identify as per dwg & Stock Location: <u>St 225</u>	0.00							
190						3			APR 20 2015
Packaging	Memo	0.00							DAS 6 9-89
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									MLJ 1504-21

MLJ 150421

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 130997

130997

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 3/26/15**Required Date:** 3/26/15**Start Qty: 5.00**

Required Qty: 5.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18		Purchased	No			170	Each	199.0000	1	5			
AN526C1032R18										**		15/04/15	DAS 36 9-89
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				72					
					4523			72					
				ST327				127					
					108079			127		3			
D2002-015		Manufactured	No			170	Each	10.0000	2	10			
D2002-015										**		15/04/15	DAS 36 9-89
Knob													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				10					
					128884			2		2			
					129880			8		4			
D2345		Manufactured	No			170	Each	14.0000	1	5			
D2345										**		15/04/15	DAS 36 9-89
Lock Channel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				14					
					126248			14		3			
D2366		Manufactured	No			170	Each	13.0000	2	10			
D2366										**		15/04/15	DAS 36 9-89
Lock Handle													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST006				13					
					128841			13		6			

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 130997

130997

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

D2367 Manufactured No

170 Each 17.0000 1 5

D2367

Handle Knob

15/04/15 DAS 33 9-89

Location

Loc Qty

Loc Code

ST006

17

103859

11

109798

6

D2372 Manufactured No

170 Each 8.0000 2 10

D2372

Quick Release

15/04/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

8

128961

2

130044

6

D2373 Manufactured No

170 Each 6.0000 1 5

D2373

Spring

15/04/05 DAS 36 9-89

Location

Loc Qty

Loc Code

ST006

6

115706

6

D2444 Manufactured No

170 Each 0.0000 1 5

D2444

Pip Pin Assembly

15/04/05 DAS 36 9-89

B 131081 (14) B 129985 (2X)

D6201 Manufactured No

100 f 8.9720 1.054 5.547369

D6201

"T" Extrusion

15/04/08

Location

Loc Qty

Loc Code

MAT028

8.972

113608

1.062

124165

7.91

2.062
2.108

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Shop Packet Print

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

March-26-15 1:34:46 PM

Page 3

Work Order ID: 130997

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

130997

D2360

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

MS20470AD3-4

Purchased

No

170

Each

2,329.000

1

5

MS20470AD3-4

Rivet, Universal Head

**

DAS

9-89

9-89

Location

Loc Qty

Loc Code

GA

1084

111477

1084

ST311

1245

111477

1245

MS21042L3

Purchased

No

170

Each

2,223.000

3

15

MS21042L3

Nut

**

DAS

36

9-89

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

830

M131317

830

ST305

973

116549

12

126333

230

M128754

2

M131624

729

MS27039-1-13

Purchased

No

170

Each

757.0000

1

5

MS27039-1-13

Screw

**

DAS

36

9-89

Location

Loc Qty

Loc Code

GA

123

124326

123

ST273A

300

124326

300

ST285

334

125654

334

March-26-15 1:34:47 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:34:47 PM

Page 4

Work Order ID: 130997

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

130997

D2360

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

MS27039-1-15

Purchased

No

170

Each

138.0000

2

10

MS27039-1-15

Screw

**

15/04/15
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

85

m127916

85

ST285

53

m127916

52

m130388

1

6

NAS1149D0332J

Purchased

No

170

Each

1,742.000

8

40

NAS1149D0332.J

Washer

**

15/04/15
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1728

112794

16

m130325

963

m131624

749

24

NAS1149D0363J

Purchased

No

170

Each

2,381.000

2

10

NAS1149D0363.J

Washer

**

15/04/15
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

FP001

2

113288

2

GA

376

m128429

376

ST269

1434

m126319

10

m131618

1424

6

March-26-15 1:34:48 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:34:48 PM

Page 5

Work Order ID: 130997

130997

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 5.00

Required Qty: 5.00

NAS679A3W

Purchased

No

170

Each

281.0000

1

5

DAS

NAS679A3W

Nut

36

9-89

15/04/15

Location

Loc Qty

Loc Code

GA

159

1463

5

M2409

154

Mezz

122

2409

122

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART AEROSPACE LTD		Work Order: 130 997
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

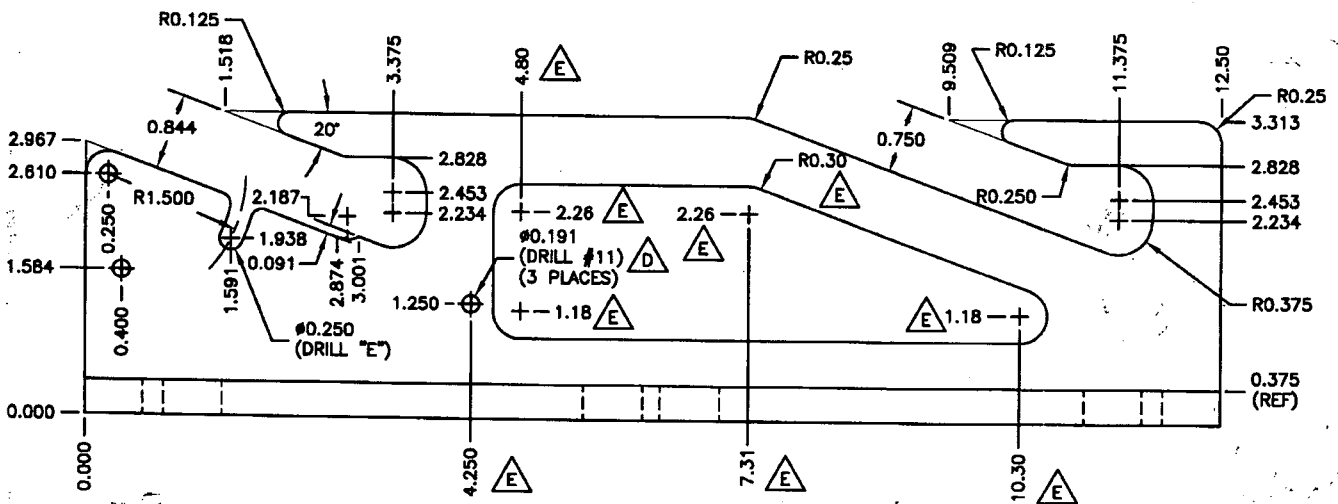
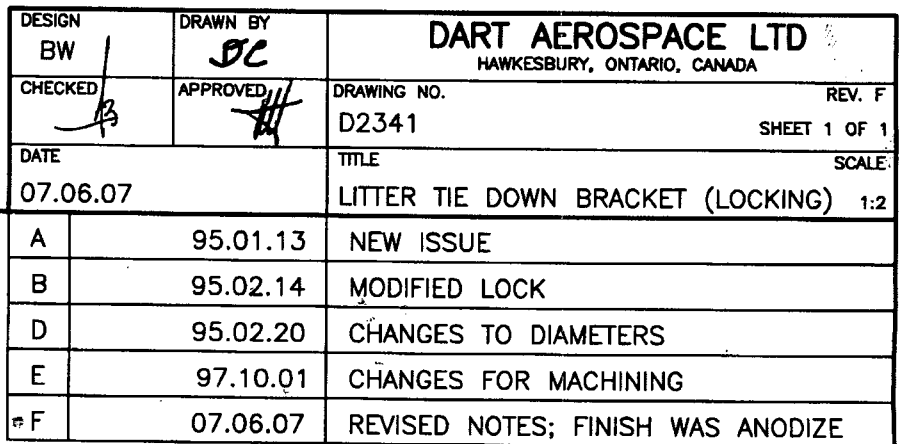
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	✓		Vern	GA-13
2.75	+/-0.030	2.750	✓		"	"
Ø0.242	+0.005/-0.001	Ø0.243	✓		"	"
Ø0.191	+0.005/-0.001	Ø0.192	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-G	ref.
R0.40	+/-0.030	R0.400	✓		"	"
12.50	+/-0.030	12.501	✓		H-G	31006
11.750	+/-0.010	11.751	✓		"	"
11.00	+/-0.030	10.999	✓		"	"
7.00	+/-0.030	6.999	✓		"	"
6.250	+/-0.010	6.250	✓		"	"
5.50	+/-0.030	5.499	✓		"	"
1.50	+/-0.030	1.498	✓		Vern	GA-13
0.750	+/-0.010	0.749	✓		"	"
0.400	+/-0.010	0.399	✓		"	"
1.584	+/-0.010	1.582	✓		"	"
2.610	+/-0.010	2.608	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.844	+/-0.010	0.842	✓		"	"
Ø0.250	+/-0.010	Ø0.250	✓		"	"
0.750	+/-0.010	0.745	✓		"	"
3.313	+/-0.010	3.312	✓		"	"
4.250	+/-0.010	4.245	✓		"	"
1.250	+/-0.010	1.251	✓		"	"

Measured by: J. A.	DAS 08
Date: 15/04/10	9-89

Audited by: JFL
Date: 2015-04-10

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	



- 1) MATERIAL: MAKE FROM D6201-D125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1); PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

RELEASED

07.06.22

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED HA	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07-06-07

PARTS LIST:

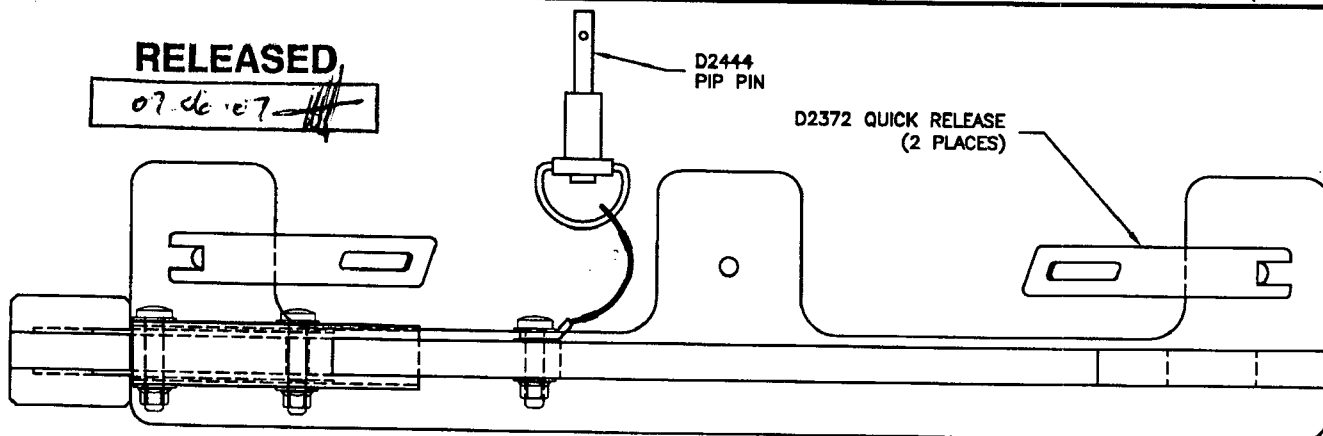
QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED LE	APPROVED #	DRAWING NO. D2360	SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE	



MS20470AD3-4
(INSTALL IN FIRST
HOLE FROM EDGE)

D2373 SPRING

D2345 LOCK CHANNEL

D2341 LITTER TIE
DOWN (LOCKING)

A

B

A

B

D2366 HANDLE
(2 PLACES)

MS27039-1-13 SCREW Δ
AN960JD10L WASHER
D2444 PIP PIN (REF)
AN960JD10L WASHER
D2341 LITTER TIE DOWN (REF)
AN960JD10L WASHER
MS21042L3 NUT

AN526C1032R18 SCREW Δ
D2002-015 KNOB
D2366 HANDLE (REF)
D2367 KNOB
D2368 HANDLE (REF)
D2002-015 KNOB
AN960JD10L WASHER
NAS679A3W NUT

D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)

D2345 LOCK
CHANNEL (REF)

D2373 SPRING
(REF)

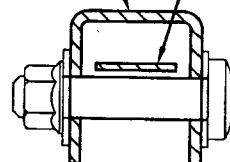
D2341 LITTER TIE
DOWN (LOCKING)

SECTION A-A
(SCALE 1:1)

MS27039-1-15 SCREW
AN960JD10L WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10 WASHER
D2341 LITTER TIE DOWN (REF)
AN960JD10 WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10L WASHER
MS21042L3 NUT

D2345 LOCK
CHANNEL (REF)

D2373 SPRING
(REF)



MS27039-1-15 SCREW
AN960JD10L WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10L WASHER
MS21042L3 NUT

SECTION B-B Δ
(SCALE 1:1)

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